

Work Order ID 64245

Tuesday, November 30, 2010 3:39:33 PM



Page 1

| | | | | | | |
|----------------|-------------|------------|-------|-------|-------|--|
| Item ID: | D3166-1 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Basket Hoop | | | | | |
| Start Date: | 11/30/2010 | Start Qty: | 12.00 | | | |
| Required Date: | 12/6/2010 | Req'd Qty: | 12.00 | | | |
| Reference: | | | | | | |

| | | | | | | | | |
|------------|---------------|-----------|-------|---------|------------|--|-------|--|
| Approvals: | Process Plan: | <i>BT</i> | Date: | 10-12-1 | Tooling: | | Date: | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | |

| | | |
|-----|-------|--|
| Run | Start | |
| | Stop | |

| Sequence II/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3166 | Rev A1 | | | | | | | | |

| | | | | | | | | | |
|----------------------|--|-----------------------------------------------------------------------------------------|------|----------|--|--|--|--|--|
| 100 | | Skidtubes | 0.00 | | | | | | |
| Large Fab | | Memo | 0.00 | | | | | | |
| Large Fab | | Cut 3/4" x 3/4" square tubing 60.00" long. | | | | | | | |
| | | | | SAO | | | | | |
| | | | | 10-12-01 | | | | | |
| 110 | | BENDING MACHINE - SKIDTUBES | 0.00 | | | | | | |
| CNC Bend 1 | | Memo | 0.00 | | | | | | |
| CNC Delta 100 Bender | | Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio 18. | | | | | | | |
| | | | | | | | | | |
| 120 | | QC6- Inspect dimensions to drawing | 0.00 | | | | | | |
| QC | | Memo | 0.00 | | | | | | |
| Quality Control | | Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302) | | | | | | | |
| | | | | | | | | | |

(12)

12 8 BEW/12/06

(42)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 64245

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|----------------|-------------|------------|-------|-------|---------------|--|
| Item ID: | D3166-1 | Accept | | Setup | Start | |
| Revision 'D': | | | | | Stop | |
| Item Name: | Basket Hoop | | | | | |
| Start Date: | 11/30/2010 | Start Qty: | 12.00 | | Cust Item ID: | |
| Required Date: | 12/6/2010 | Req'd Qty: | 12.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|-------------------------------------------------------------|----------------------|---------|-----------------|--------------|---------------|---------------|------------------|-------------------------------------|
| 130 Packaging Packaging | Identify as per dwg & Stock Location: <u>WA</u> Memo | 0.00 0.00 | | SAD 10-11-09 | | <u>12</u> | | | |
| 140 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 10/12/09 PR 10-12-9 <u>12</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 30, 2010 3:39:37 PM

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Work Order ID: 64245



Parent Item: D3166-1



Parent Item Name: Basket Hoop

Start Date: 11/30/2010

Required Date: 12/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 02.08.23 New issue KJ
IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ
Verified by: EC
IPP Rev: C 09-01-23 as per DEO D3166-A2 DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.065 | | Purchased | No | | | 100 | f | 1,189.168 | 5 | 63.15789 | | | |
| | | | | | | | | | | | | | |
| 304 SQ Tube .75x.75x.065W | | | | | | | | | | | | | |



SAD

10-12-01

Location

Loc Qty

Loc Code

MAT

1089.43205

112398

0

115494

4.4725

115593

84.95955

116267

1000

WA

99.736185

115274

4.712185

115901

95.024

31.5789

31.5789

| W/O: | | WORK ORDER CHANGES | | | | | |
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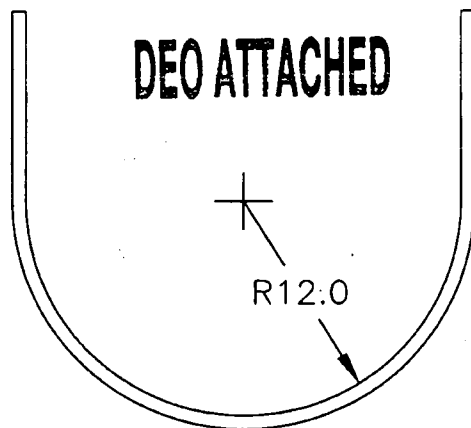
NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3166 | REV. A SHEET 1 OF 1 |
| DATE 02.07.10 | | TITLE BASKET HOOP | SCALE NTS |
| A | 02.07.10 | NEW ISSUE | |
| A1 | 04.04.08 | 38+/-1 WAS 36.0 | |

RELEASED
02.08.06

DEO ATTACHED



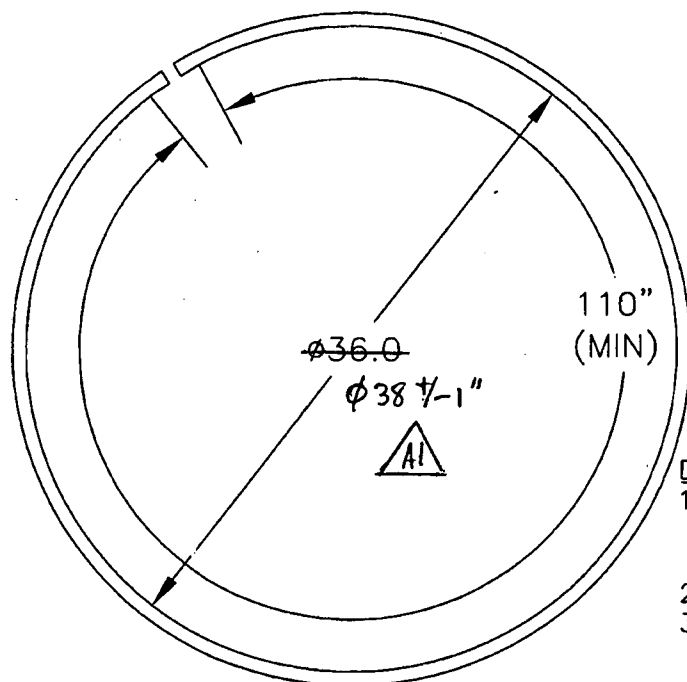
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 04245
2810-12-1



D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|----------------------|-------------------------------|----------------------------------|-----------------------------------------|--|--------------------------------|---------------------|--------------|
| DRAWING NO. D3166 | TITLE BASKET HOOP | REV A1 | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3166-A-2 | SHEET NO. 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | DE APPR. <i>[Signature]</i> | | |
| DATE 08.12.11 | DATE 08.12.15 | DATE 08/12/15 | DATE 08/12/16 | | DATE 08.12.16 | | |

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,
120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)

RELEASED
08/12/16 *[Signature]*

REASON: SEE PAR 08-005

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